

August-27-13 1:21:59 PM

Item ID: D4903-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Skipaw, RH

Start Date: 27/08/2013 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 30/08/2013 **Req'd Qty:** 2.00 ***~***

Customer:

Reference: PL 13.08.27


Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4903	

120

0.00

120

FLOW WATER JET

Wateriet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File
D4903-1 BLANK

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D4903
3-Debur
PROGRAM REV: A
FOLIO REV: AA

Work Order ID 105952

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105952

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Item ID: D4903-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Skipaw, RH
Start Date: 27/08/2013 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 30/08/2013 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location <i>Col</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									

col 13/07/06

2 p

B-a 13/09/08

2 d

*DAS
08
13/09/08*

2

8/13/09/19

Work Order ID 105952

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105952

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Item ID: D4903-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Skipaw, RH

Start Date: 27/08/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/08/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

13/9/2013
mf
13-9-19

Picklist Print

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Page 1

Work Order ID: 105952
Parent Item: D4903-1
Parent Item Name: Fwd Skipaw, RH

Start Date: 27/08/2013 Required Date: 30/08/2013
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP REV:A NEW ISSSUE 13-08-27 JLM VERIFIED BY:DD

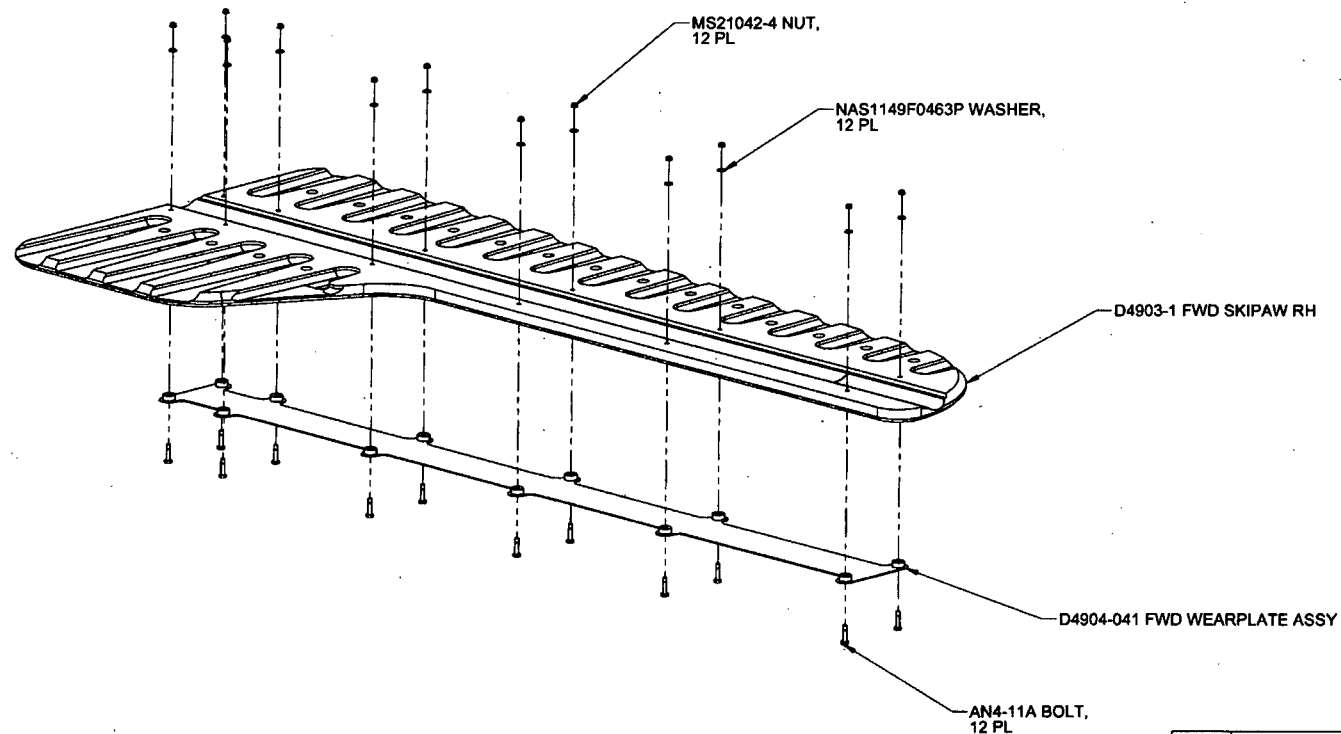
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	670.0003		34.147368			
UHMW 1" Black										35			

Im 13-08-28

Location	Loc Qty	Loc Code
MAT019	670.0002895	
121278	11.0002895	
122575	47.6	
123229	53	
123704	63.8	
123949	6.96	
124382	197.12	
124758	17.52	
125137	273	

125137

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4903-041	FWD SKIPAW ASSY RH
1	1	D4903-1	FWD SKIPAW RH
2	1	D4904-041	FWD WEARPLATE ASSY
3	12	NAS1149F0463P	WASHER (AN960JD416)
4	12	MS21042-4	NUT
5	12	AN4-11A	BOLT



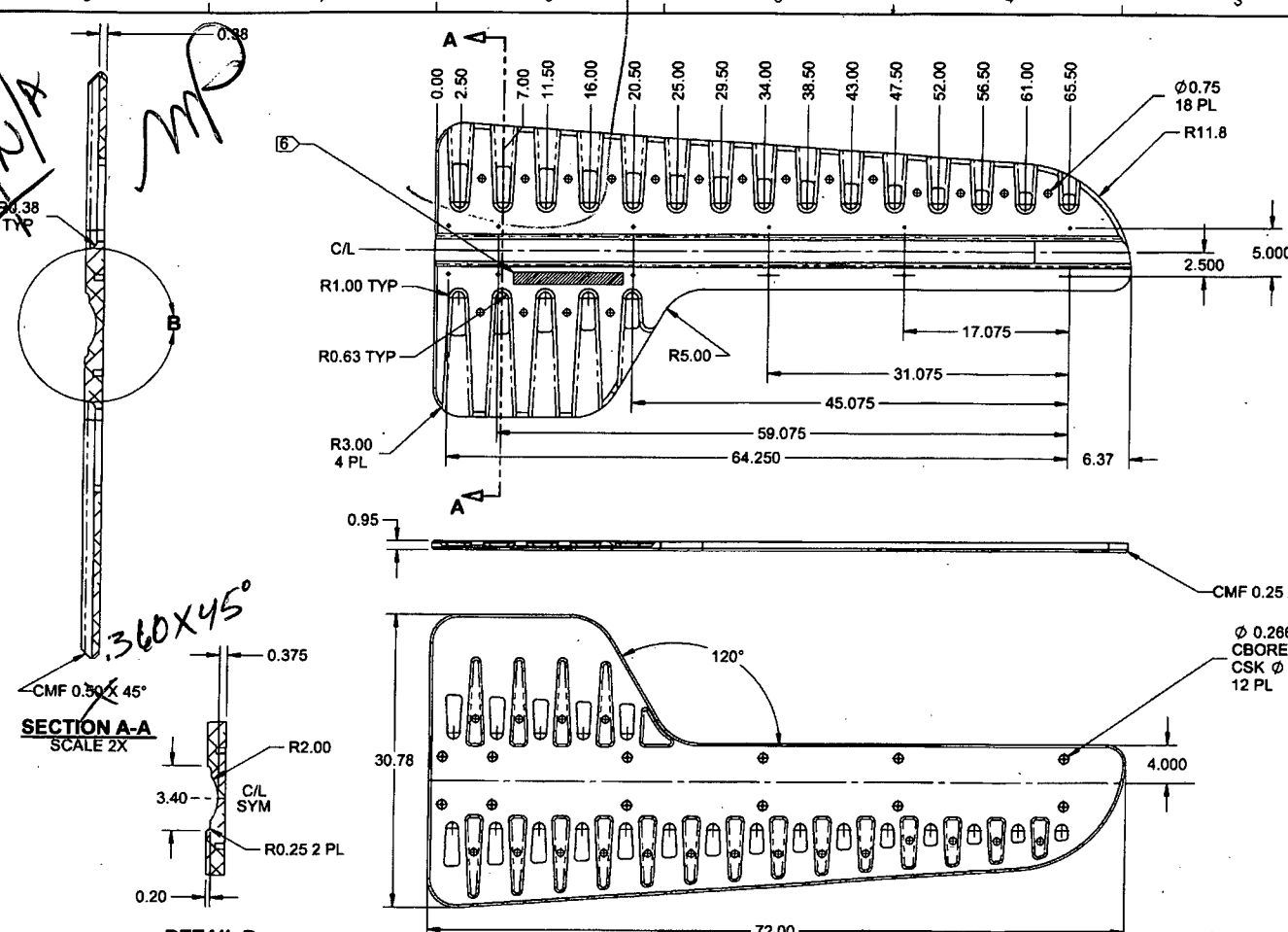
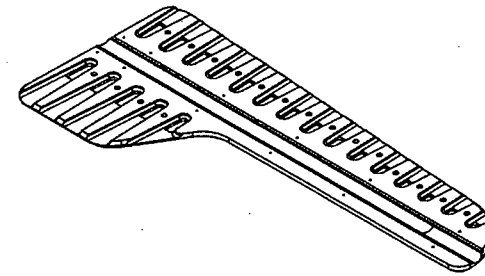
D4903-041 FWD SKIPAW ASSY RH

RELEASED
2013-08-12

A	NEW RELEASE	DB	13.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D4903	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	FWD SKIPAW RH	NTS
DATE	13.07.22	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Full
2/A

mf



D4903-1 FWD SKIPAW RH

RELEASED
2013-08-12

- NOTES:**
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMB100
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: ENGRAVE DART P/N "D4903-1" AND B/N USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010 PER QSI 044, METHOD 6.3
 - 7) WEIGHT: 27.28 lbs
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4903-1-A.IGES

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D4903	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD SKIPAW RH	NTS
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DART AEROSPACE LTD	Work Order: 105952
Description: FWD SKIDPAW, RH	Part Number: D4903-1
Inspection Dwg: D4903 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38	$\pm .030$.380	✓		Vern	M2-DL
* 3.60 X 45	$\pm .030$.360	✓		"	"
.375	$\pm .010$.381	—		"	"
3.40	$\pm .030$	3.400	—		"	"
.20	$\pm .030$.200	—		"	"
R.25	$\pm .030$	R.250	—		R-G	
30.78	$\pm .030$	30.780	—		M-type	M1-D8
72.00	$\pm .030$	72.000	—		"	
.95	$\pm .030$.955	—		"	
.25 X 45°	$\pm .030 \pm 1/2^\circ$.260 X 45°	—		Vern	M2-DL
Ø.266	$\pm .006$ $\pm .001$	Ø.265	—		"	"
Ø.950 X .50	$\pm .010 \times \pm .030$	Ø.950 X .497	—		"	"
R1.00	$\pm .030$	R1.000	—		"	"
5.000	$\pm .005$	5.000	—		"	"
6.37	$\pm .030$	6.370	—		M-type	M1-DL
17.075	$\pm .005$	17.075	—		"	
31.075	$\pm .005$	31.075	—		"	
45.075	$\pm .005$	45.075	—		"	
59.075	$\pm .005$	59.075	—		"	
64.250	$\pm .005$	64.250	—		"	
2.50	$\pm .030$	2.500	—		"	
34.00	$\pm .030$	34.000	—		"	
65.50	$\pm .030$	65.500	—		"	

Measured by: <i>gm</i>	Audited by: <i>G.A.</i> (DAS 08 08)	Preliminary Approval:
Date: 13/09/06	Date: 13/09/08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15